



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4032-041
Job Sheet 178122



Part No: D4032-041

Job Qty: 1 ea

Part Name: Short Basket Assembly (350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/26/18

Job Tracking No:

Due Date: 6/8/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E SHEETS 1,3,4 IPP RevA: new issue DD 09.12.02 verified by:EC IPP Rev:B as per PA3 DD 10.03.10 verified by:EC IPP Rev:C as per RevA DD 10.03.23 verified by:EC IPP Rev:D as per dwg revC DD 10.04.20 verified by:EC IPP Rev:E as per dwg revD DD 10.08.18 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/8/18	6/8/18	0.00	0.00	Start Up Stores/Pkg-1		BEB 18-06-14
100	Packaging	1 pcs	6/8/18	6/8/18	0.00	0.00	Packaging1-4		BEB 18-06-15
110	HandFinish	1 pcs	6/8/18	6/8/18	0.00	1.16	HandFinish4		BEB 18-06-15
120	QC	1 pcs	6/8/18	6/8/18	0.00	0.00	QC5		38
130	Packaging	1 pcs	6/8/18	6/8/18	0.00	0.00	Packaging3-2		9-88
140	QC21-SA	1 Ea	6/8/18	6/8/18	0.00	0.00	QC21		DAG 21 JUN 22 2018

Part Op 110 - ****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label ****

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-14A	Bolt	4 Ea (4 ea)	90-Start up Operation	5067270
AN3-16A	Bolt	2 Ea (2 ea)	90-Start up Operation	5045859
AN310-4	Nut	3 Ea (3 ea)	90-Start up Operation	5060062
AN310C4	Nut	2 Ea (2 ea)	90-Start up Operation	5057494
AN4-12	Bolt	3 Ea (3 ea)	90-Start up Operation	5064082
AN5-17A	Bolt	4 Ea (4 ea)	90-Start up Operation	5068080
D2530	Handle Weldment	1 Ea (1 ea)	90-Start up Operation	5068075
D2535	Spring	2 Ea (2 ea)	90-Start up Operation	5054449
D2537	Bushing	2 Ea (2 ea)	90-Start up Operation	5050459
D3917-3	Washer	6 Ea (6 ea)	90-Start up Operation	old 5057741
D3953-17	Gas Spring Spacer	2 Ea (2 ea)	90-Start up Operation	5067458
D3953-19	Gas Spring Bracket	1 Ea (1 ea)	90-Start up Operation	5051316
D3953-21	Gas Spring Bracket	1 Ea (1 ea)	90-Start up Operation	5051311
D3953-3	Gas Spring Stud, Lid	2 Ea (2 ea)	90-Start up Operation	5051533
D3953-7	Spring Spacer	2 Ea (2 ea)	90-Start up Operation	5059063
D3953-9	Gas Spring Washer	2 Ea (2 ea)	90-Start up Operation	5075339
D3969-3	Spring (Basket Lid)	1 Ea (1 ea)	90-Start up Operation	5069093
D4017-041	Short Basket Base Assembly (350)	1 Ea (1 ea)	90-Start up Operation	5078973
D4018-041	AS350 Short Basket Lid Assembly	1 Ea (1 ea)	90-Start up Operation	5076284
MS21042L3	Nut	6 Ea (6 ea)	90-Start up Operation	5075328
MS21042L5	Nut	4 Ea (4 ea)	90-Start up Operation	5041167
MS24665-151	Cotter Pin	3 Ea (3 ea)	90-Start up Operation	5053961

003868

Plex 5/28/18 7:28 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

MS24665-300	Cotter Pin	2 Ea (2 ea)	90-Start up Operation
NAS1149C0432R	Washer	2 Ea (2 ea)	90-Start up Operation
NAS1149F0332P	Washer	8 Ea (8 ea)	90-Start up Operation
NAS1149F0432P	Washer	6 Ea (6 ea)	90-Start up Operation
NAS1149F0563P	Washer	4 Ea (4 ea)	90-Start up Operation

5844188
5050057
5068663 -
5050055
5054114 5080659

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-14A	4	238	0
	AN3-16A	2	72	0
	AN310-4	3	121	0
	AN310C4	2	131	0
	AN4-12	3	161	0
	AN5-17A	4	232	0
	D2530	1	16	0
	D2535	2	78	0
	D2537	2	36	0
	D3917-3	6	43	0
	D3953-17	2	87	0
	D3953-19	1	48	0
	D3953-21	1	42	0
	D3953-3	2	24	0
	D3953-7	2	36	0
	D3953-9	2	17	0
	D3969-3	1	26	0
	D4017-041	1	0	0
	D4018-041	1	0	0
	MS21042L3	6	1,322	0
	MS21042L5	4	737	0
	MS24665-151	3	381	0
	MS24665-300	2	88	0
	NAS1149C0432R	2	2,245	0
	NAS1149F0332P	8	3,278	0
	NAS1149F0432P	6	1,511	0
	NAS1149F0563P	4	725	0

Part Specifications

Specifications could not be found.

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Container No: S081225



Part: D4032 - 041

Job No: 178122

Serial No/Batch: S081225

Revision:

Inspector:

Exp Date:

Instructions:

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/14/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval 	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
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